



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D205-596-103GB
Job Sheet 185675



Part No: D205-596-103GB

Job Qty: 1 ea

Part Name: Aft Crosstube - Extended Height 39" (Gloss Black)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/31/18

Job Tracking No:

Due Date: 12/10/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: D250-596-103 REV.C IIN-D205-596 REV.F IPP REV:A 18.10.29 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	12/10/18	12/10/18	0.00	0.00	Start Up Crosstubes-1		DPZ
105	HandFXtube	1 pcs	12/10/18	12/10/18	0.00	0.33	HandFinish5		GP 2018-11-14
107	QC	1 pcs	12/10/18	12/10/18	0.00	0.00	QC7-1		GP 2018-11-14
110	CNC Bend Crosstubes	1 pcs	12/10/18	12/10/18	0.00	1.35	CNC Bend Crosstube		GP 2018-11-14
120	Crosstubes	1 pcs	12/10/18	12/10/18	0.00	0.33	Crosstubes-1		DPZ DAS 38
130	QC	1 pcs	12/10/18	12/10/18	0.00	0.00	QC15		GP 2018-11-27
140	Crosstubes	1 pcs	12/10/18	12/10/18	0.00	0.33	Crosstubes-1		GP 2018-11-27
150	HandFXtube	1 pcs	12/10/18	12/10/18	0.00	0.33	Crosstubes-3		GP 2018-11-27
160	QC	1 pcs	12/10/18	12/10/18	0.00	0.00	QC7-1		38 DAS
170	QC	1 pcs	12/10/18	12/10/18	0.00	0.00	QC5		38 DAS
180	SprayPaint	1 pcs	12/10/18	12/10/18	0.00	0.50	Spray Paint		AS 18-11-28
190	QC	1 pcs	12/10/18	12/10/18	0.00	0.00	QC14		2/3
200	Crosstubes	1 pcs	12/10/18	12/10/18	0.00	0.33	Crosstubes-1		AS 18-11-28
210	QC	1 pcs	12/10/18	12/10/18	0.00	0.00	QC5		38 DAS
220	Packaging	1 pcs	12/10/18	12/10/18	0.00	0.00	Packaging3-1		DEC 06 2018
225	DC	1 pcs	12/10/18	12/10/18	0.00	0.00	DC		DEC 06 2018
230	QC21-FG	1 Ea	12/10/18	12/10/18	0.00	0.00	QC21		DEC 06 2018

Part Op 105 - Crosstubes Chemical Conversion

Descriptions: 107 - QC7-Inspect Chemical Conversion Coat

110 - Bend as per dwg D2890 using CNC bender program

120 - 1-Mark 37.30" for cutting from tangential line in the straight section from D2890 as per Dwg wall template.

130 - QC15- Crosstube Dimensional Check

140 - 1-Cut as per Dwg D205-596-103 2-Deburr & Inspect for surface damage. Polish cut surface.Scribe part # and batch # on one end of tube.

150 - ***IMMEDIATELY AFTER GRINDING*** 1- PRESSURE WASH X-TUBE INSIDE AND OUT 2- ALODINE AND ACID ETCH X-TUBE INSIDE AND OUT AS PER QSI005.

160 - QC7-Inspect Chemical Conversion Coat

170 - QC5- Inspect part completeness to step on W/O

180 - 1-Prime inside and outside per DWG QSI 005 4.2 PRIMER BATCH: 138962 2- Paint (GLOSS BLACK) outside as per dwg QSI 005 4.2 PAINT BATCH: 5131486

190 - QC14- Inspect Spray Paint

200 - 1- Lightly scuff the bonded area using a 180 grit sand paper and clean the area with 41058 wash 'n' wipe 2- Apply Proseal as per dwg D205-596-103. A/R Proseal 890 B-2 Batch: 5096374 EXP: 3/19 3- Install clamps as per dwg (Note 12) Torque clamps 80 to 100 in-lb as per dwg and Note 13)

210 - QC5- Inspect part completeness to step on W/O

220 - Identify and pack for shipping as per PPP D205-596-103 Location: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6008-180	Crosstube Extrusion	1 Ea (1 ea)	90-Start up Operation	B153572
D2940-1	Support	2 Ea (2 ea)	200-Crosstubes	
D3595-063-530	Rubber Cushion 0.63" Wide X 5.30" Long	4 Ea (4 ea)	200-Crosstubes	
MS21920-28	Clamp	4 Ea (4 ea)	200-Crosstubes	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6008-180	1	7	0
200-Crosstubes	D2940-1 S125887	2	3	0
	D3595-063-530 S108625	4	65	0
	MS21920-28 S100462	4	68	0

Part Specifications

Specifications could not be found.

Plex 10/31/18 11:31 AM Dart.lajeunesse.marie



Container No: S127313



Part: D205-596-103GB

Job No: 185675

Serial No/Batch: S127313

Revision: C/F

Inspector:

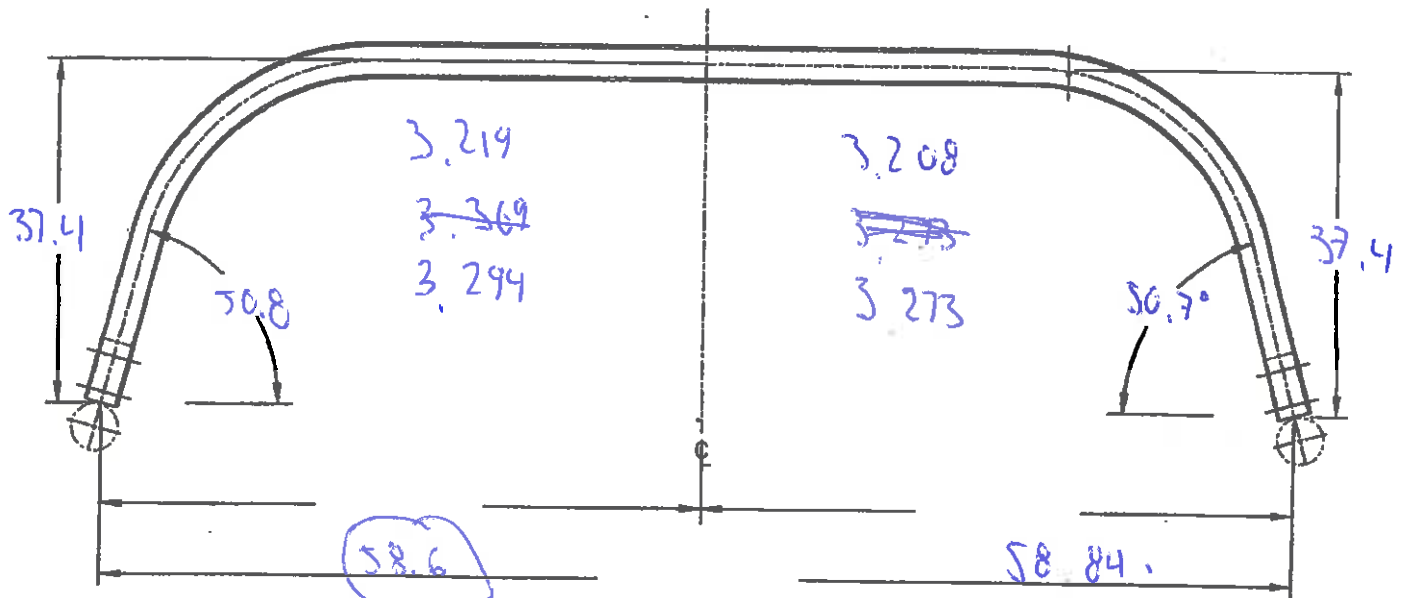
Exp Date:

Instructions: TC STC SH03-6 Issue 4, EASA STC SR01742NY 13/11/04, EASA ST

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EART AEROSPACE LTD		Work Order:	
Description: Crosstube High-High Aft		Part Number:	D205-596-103
Inspection Dwg: D205-596-103 Rev: B		Page 1 of 1	

Required Dimension	Min	Max
Height	37.2	37.4
1/2 Span	58.7	58.9
Angle	49	52
Total Span	117.4	117.8
Bending Passes	3	--
Crushing	--	6%



	Side A	Side B
Bending Passes	9	9
Crushing	1.2%	1.2%
Comments		

QC15 Inspection	DAS 38
Date	MMV 22/10/10

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	08.04.21	Dwg Rev updated	KJ/JM	
C	12.04.16	Added bending, crushing dimensions	KJ	



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: 185675		DISPOSITION		DEPARTMENT/PROCESS				Engineering			
Part No. D205-596-103GB		Rework ☐ Scrap ☐ Use-as-is ☒		Skid-tube ☐ Machining ☐ Large Fab ☐		Cross tube ☒ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐		Water Jet ☐ Supplier ☐ Quality ☐	
Date: _____	Sequence #: _____	QTY Affected: 1		MRB (QSI042) No on behalf CP							
Description Work Order Deviation				Disposition							
half span measured at 58.6. Tolerance on half span 58.7-58.9				Acceptable to engineering - use as is. See attached e-mail for CP approval							
Root Cause				QC / QA Coordinator DAS 55 19-7-11							
Operator ☒ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				Fault Category							
Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____				Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐				Positioned Wrong ☐ Outside Tolerance ☒ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			

Nazim Ould-Brahim

From: Chris Provencal
Sent: Thursday, November 15, 2018 2:11 PM
To: Nazim Ould-Brahim
Subject: Re: D205-596-103 Crosstube WO-NCR

The dimensions are acceptable.

Chris

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From: Nazim Ould-Brahim
Sent: Thursday, November 15, 2018 10:08:50 AM
To: Chris Provencal
Subject: D205-596-103 Crosstube WO-NCR

Hey Chris,

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Job BOM

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Part Specifications

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Container No: S127313



Part: D205-596-103GB

Job No: 185675

Serial No/Batch: S127313

Revision: C/F

Inspector:

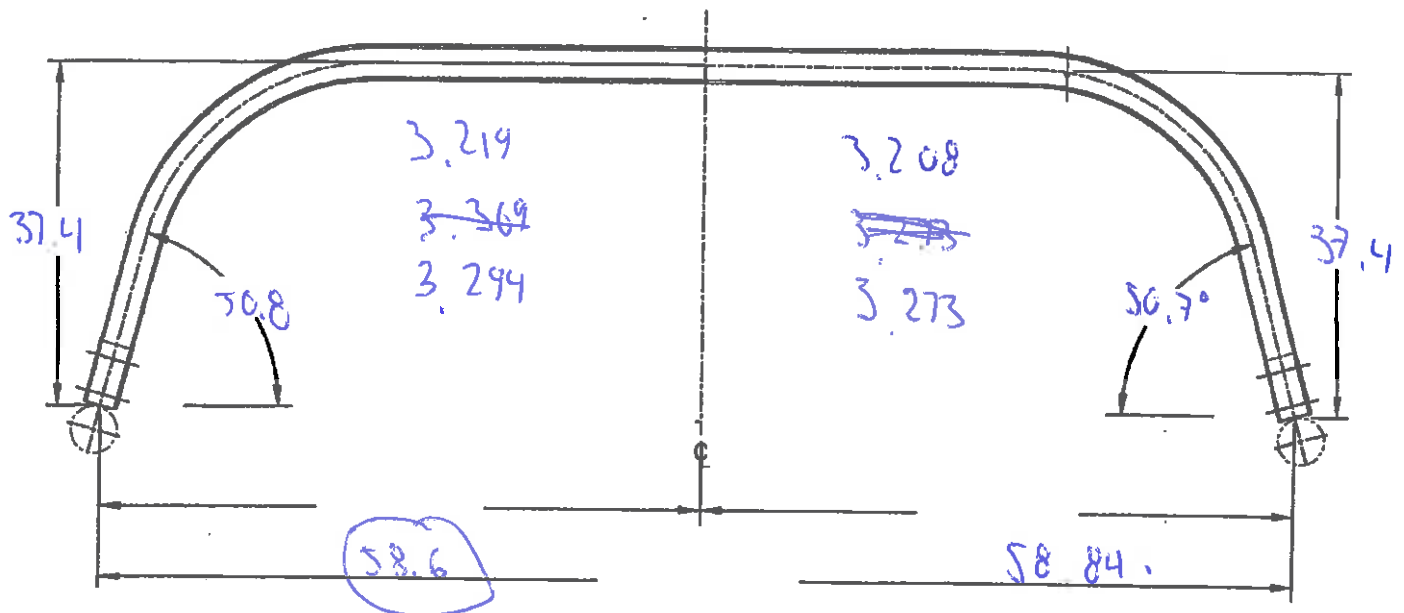
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BART AEROSPACE LTD		Work Order:	
Description: Crosstube High-High Aft		Part Number:	D205-596-103
Inspection Dwg: D205-596-103 Rev: B		Page 1 of 1	

Required Dimension	Min	Max
Height	37.2	37.4
1/2 Span	58.7	58.9
Angle	49	52
Total Span	117.4	117.8
Bending Passes	3	--
Crushing	--	6%



	Side A	Side B
Bending Passes	9	9
Crushing	1.2%	1.2%
Comments		

QC15 Inspection	DAS 38
Date	NNV 22 7/10

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	08.04.21	Dwg Rev updated	KJ/JM	
C	12.04.16	Added bending, crushing dimensions	KJ	

Entered: _____

Date: _____

NCR No. _____

19-7302

Job: _____

185675

Part No. _____

D205-696-103GB

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

DISPOSITION		DEPARTMENT/PROCESS				QTY Affected : 1		Sequence #: _____		Date : _____	
Description Work Order Deviation		Disposition				MRTB (QSI042)		Completed By		Lead hand / Supervisor	
half span measured at 58.6. Tolerance on half span 58.7 - 58.9		Acceptable to engineering. use as is. See attached e-mail for CP approval				No on behalf CP		No on behalf CP		QC / QA Coordinator DAS 55 9-89 19-7-11	
Root Cause ☐ Operator ☒ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up				☐ Positioned Wrong ☒ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread					

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